

Work Order ID 47430

June 26, 2009 12:16:09 PM



Page 1

Item ID: D3514-043
Revision ID: A
Item Name: Top Mounted Gimbal Assembly

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 2.00
Required Date: 03/08/2009 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *m F*
QC:

Date: *09/09/24* Tooling:

Date:

Run Start



Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3514	Rev A
-------	-------

100	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D3514								

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

09/10/01 (2) (PW)

=> 802/00/01

(re) f

9/10/1 (2) (SL)

Work Order ID 47430

June 26, 2009 12:16:09 PM



Page 2

Item ID: D3514-043

Accept



Setup Start



Revision ID: A

Item Name: Top Mounted Gimbal Assembly

Stop



Start Date: 15/07/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/05

09-10-2

Picklist Print

June 26, 2009 12:16:09 PM

Page 1

Work Order ID: 47430

Parent Item: D3514-043RevA

Parent Item Name: Top Mounted Gimbal Assembly

Start Date: 15/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

[illegible]

Date: Thursday, 23/04/2009 3:30:03 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GPS RECEIVER HOUSING	
Job Number :	47430			
Estimate Number :	12887			
P.O. Number :		Part Number :	D3514043	
This Issue :	23/04/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3514 REV.A	
First Issue :	//	Project Number :	N/A	
Previous Run :	45419	Drawing Revision :	A	
Written By :		Material :		
Checked & Approved By :	JUD 09-04-24	Due Date :	20/05/2009	Qty: 2 Um: Each
Comment :	Est Rev:A New Issue 07-09-24 EC verified by DD			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	✓ D3514047	Top Mounted Housing Assembly
-----	------------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

TOP MOUNTED HOUSING ASSEMBLY

Batch: 47520

9/6/14

9/6/10/01

2.0	✓ D35221	Gasket
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B35370

9/6/14

SD

3.0	✓ D35233	Leg
-----	----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

LEG

Batch: B35752

9/6/14

SD

(P7C)

4.0	✓ D35241	Lower Plate
-----	----------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

LOWER PLATE

Batch: B34803

9/6/14

SD

5.0	✓ D3531041	Bracket Assembly
-----	------------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BRACKET ASSEMBLY

Batch: B35371

9/6/14

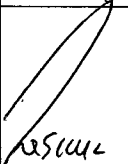
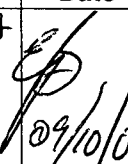

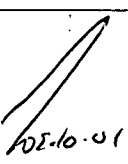
SD

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3514-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47430</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/10/01	3.0	D3523-3 Qty B35752 was found with out helicoil installed upon assembly. looking at the parts it appears to be installed right at the bottom.		Acceptable to use, both length is good.	 09/10/01	S 09/10/01		 05/10/01

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:30:03 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 47430

Part Number: D3514043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



D35333

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Set Screw

Batch: ~~B34899~~ B34899

9/6/11

SP

7.0



AN36A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109152

9/6/11

SP

8.0



AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M18235

9/6/11

SP

9.0



MS24693S29

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Batch: M10395

9/6/11

SP

10.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3514

8/509/10/01 (2)

11.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/10/11 (2)

12.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:30:03 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 47430

Part Number: D3514043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

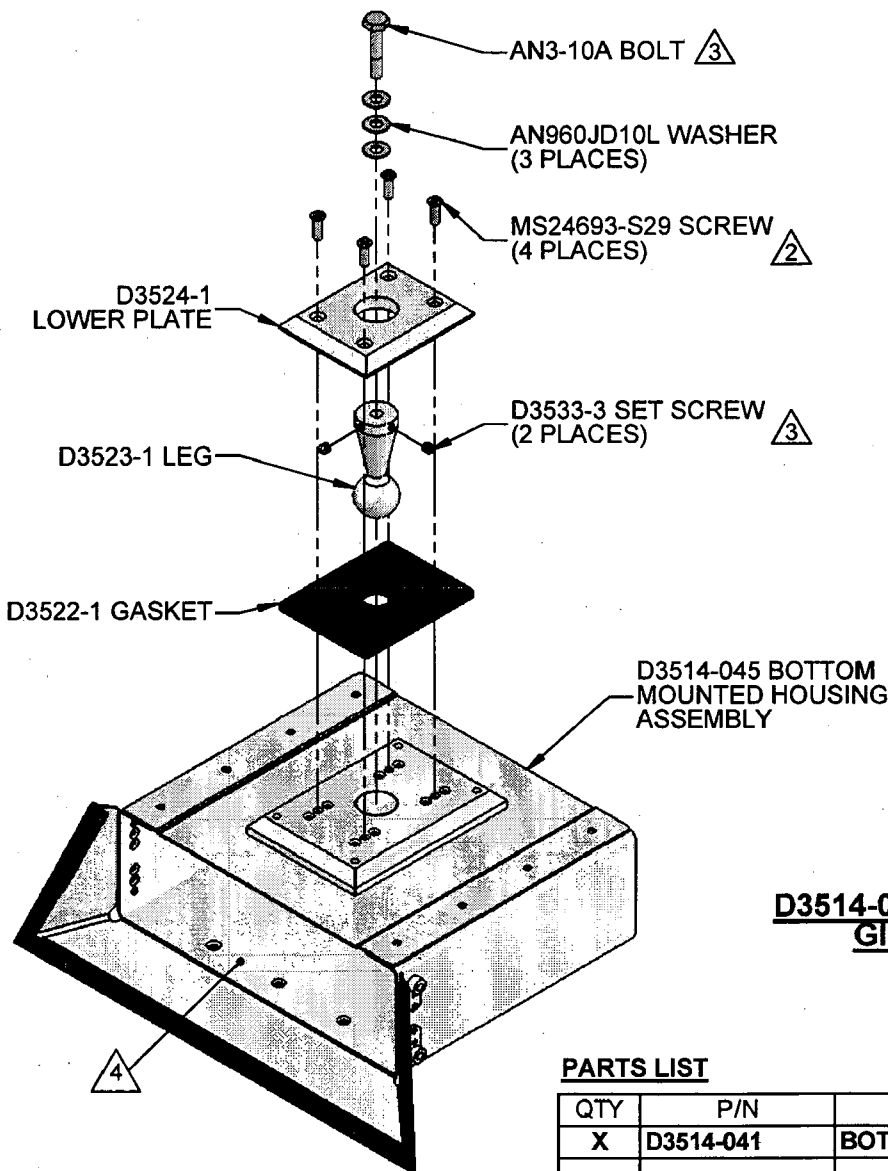
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 1 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	
REV A		DESCRIPTION NEW ISSUE	



RELEASED
07.08.05

**D3514-041 BOTTOM MOUNTED
GIMBAL ASSEMBLY**

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO **47431**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

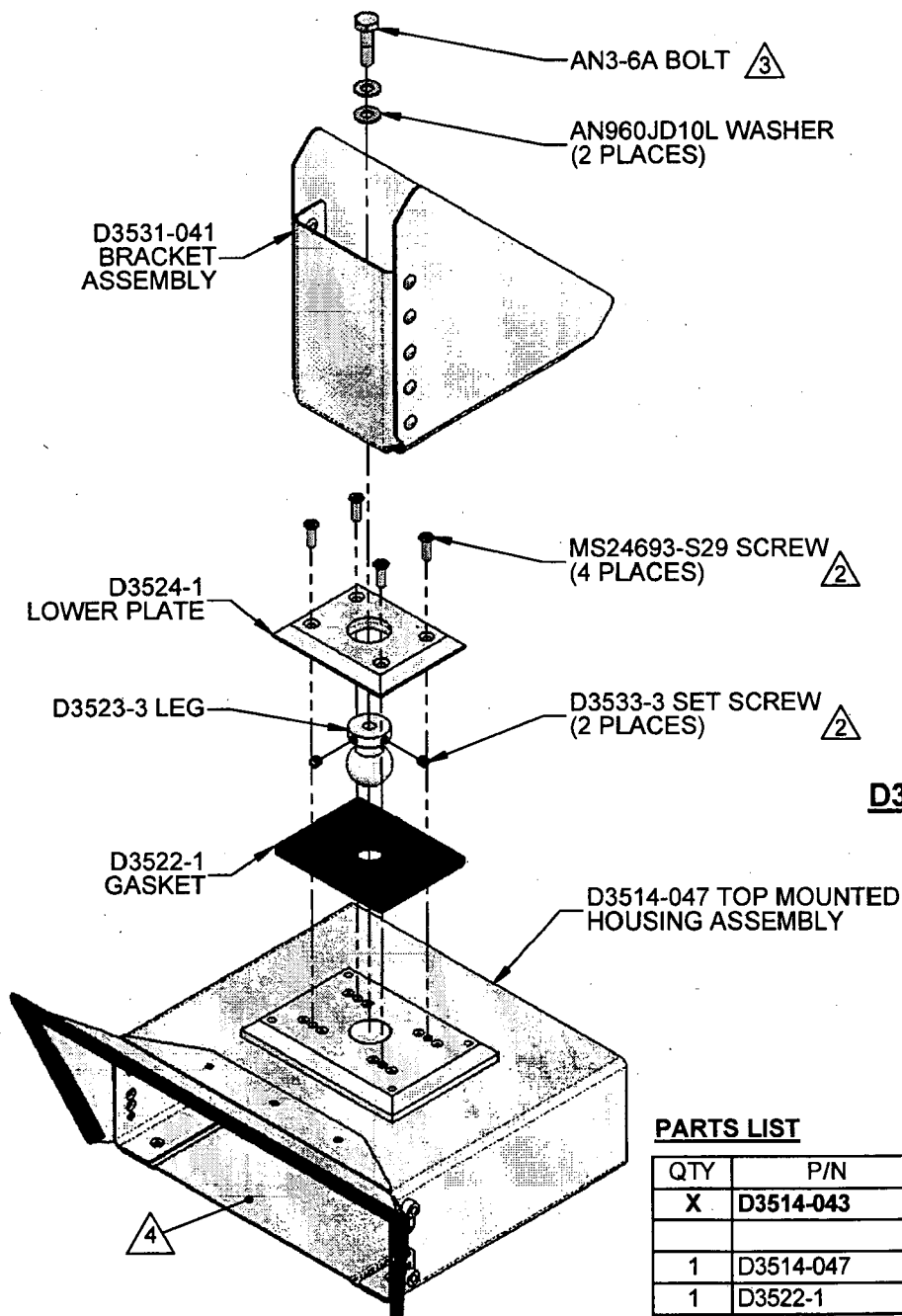
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 2 OF 9 SCALE 1:3

RELEASED
07.08.03



**D3514-043 TOP MOUNTED
GIMBAL ASSEMBLY**

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WITHOUT NOTICE
WORK ORDER
NO. **47430**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

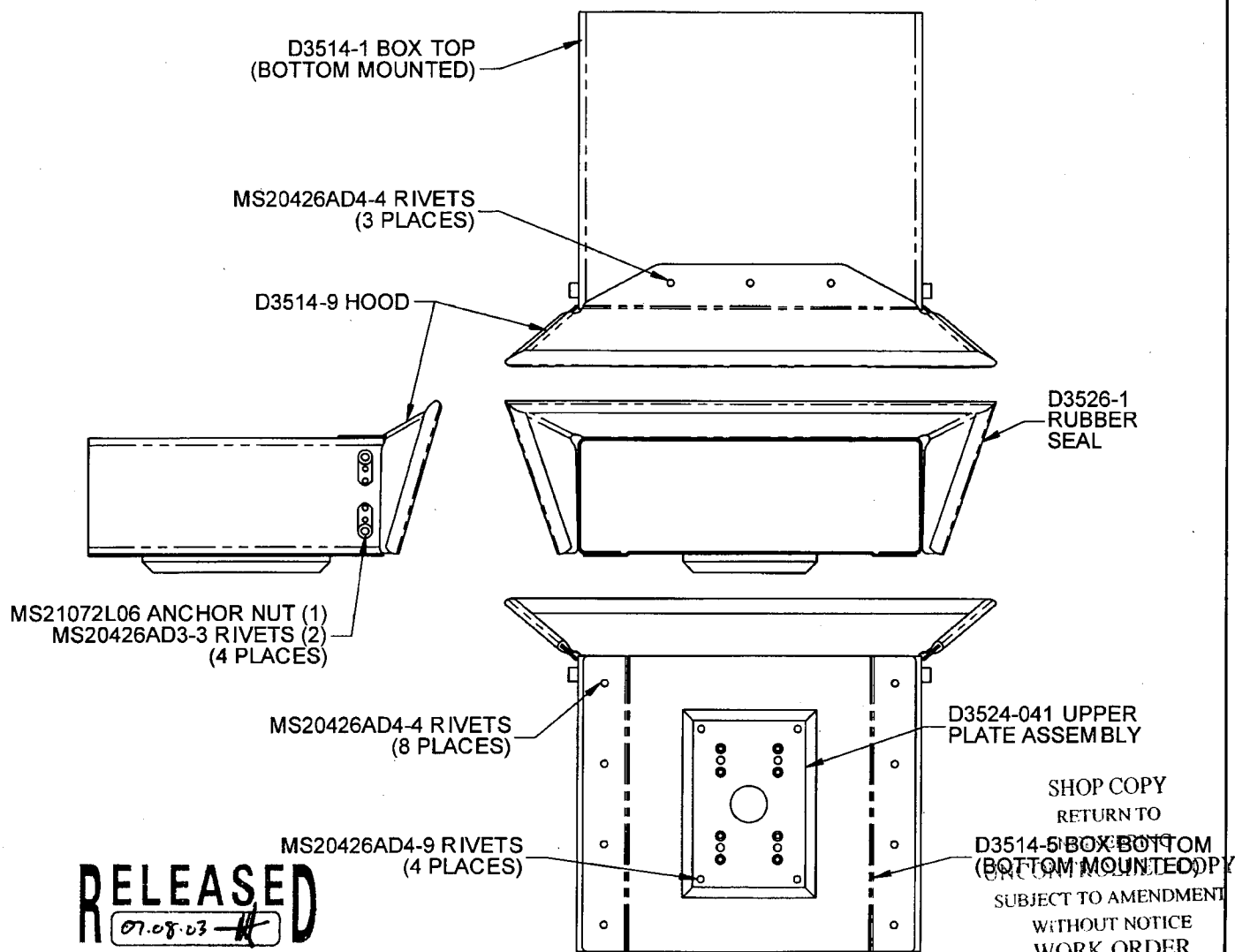
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

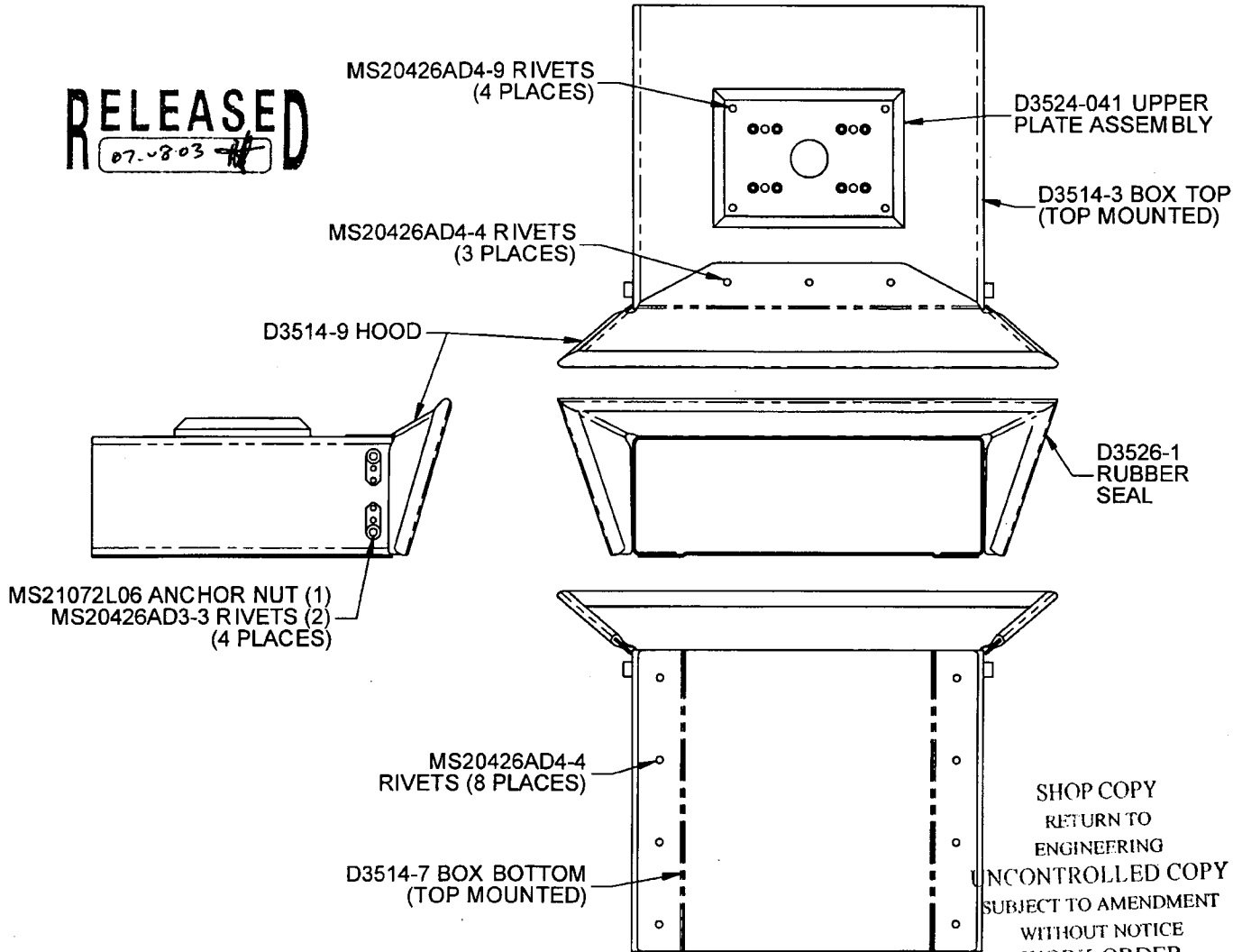
QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

RELEASED
07-08-03 [Signature]**D3514-047 TOP MOUNTED
HOUSING ASSEMBLY****NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

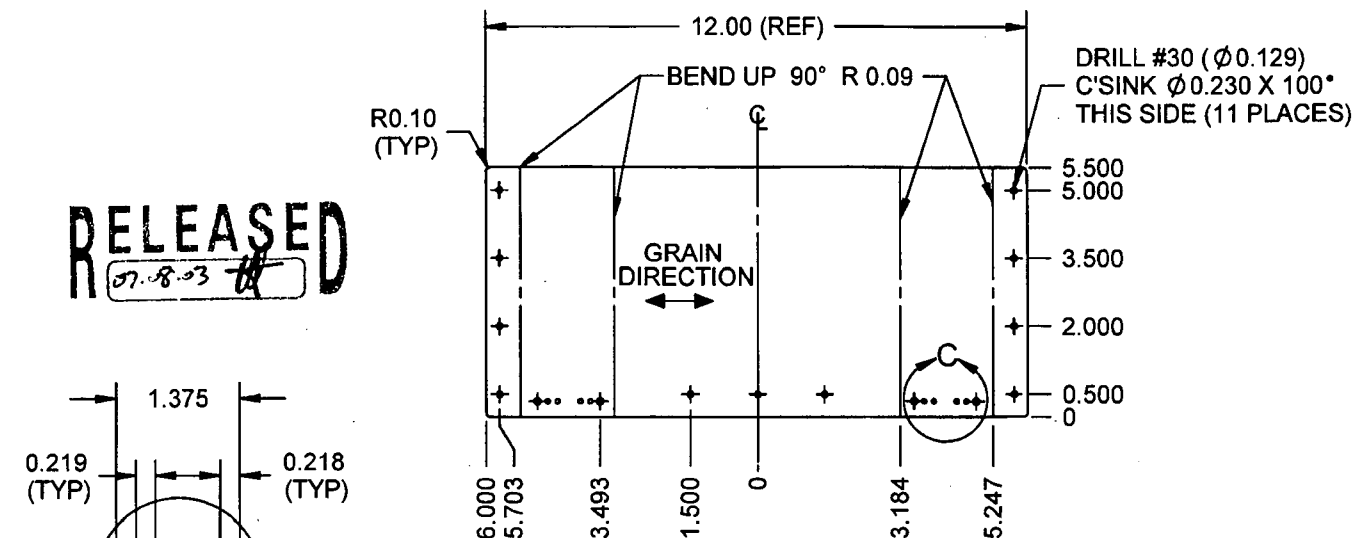
QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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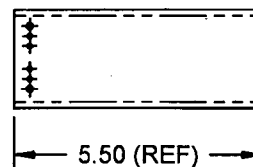
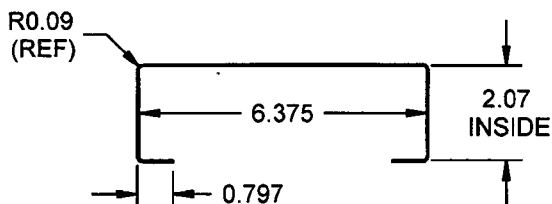
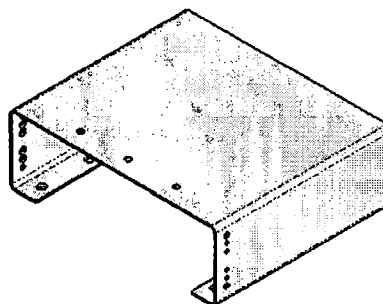
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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	SCALE 1:4



**D3514-1F
FLAT PATTERN**



D3514-1 BOX TOP (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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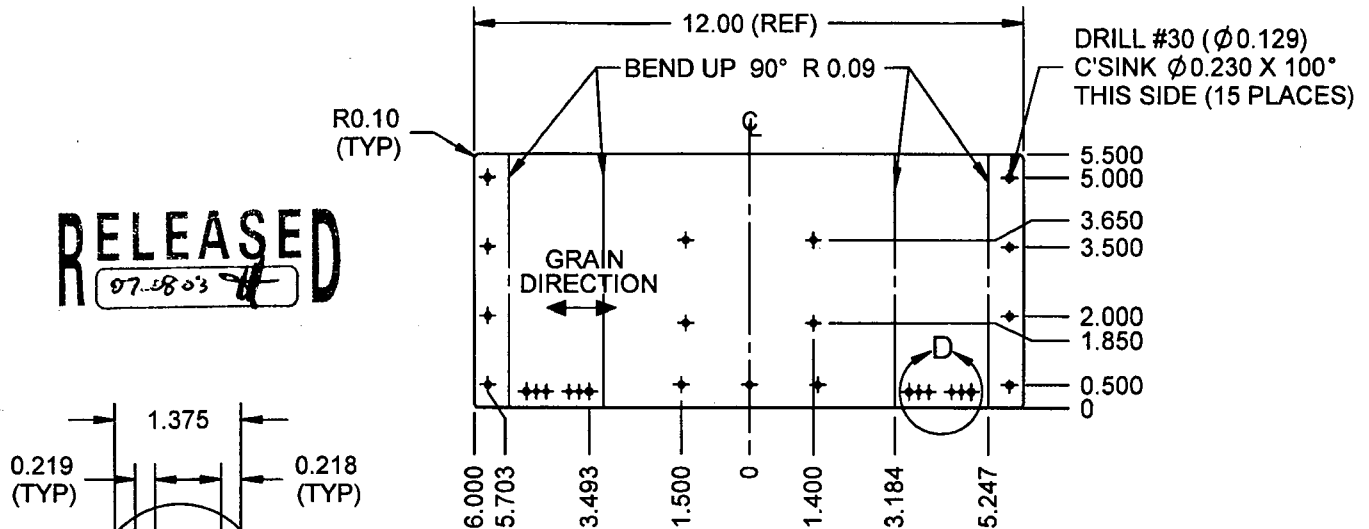
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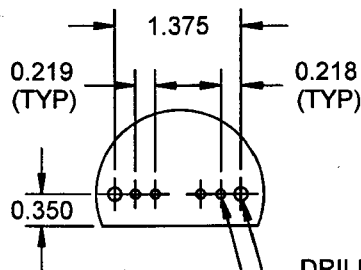


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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:4

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07-18-03



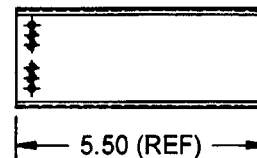
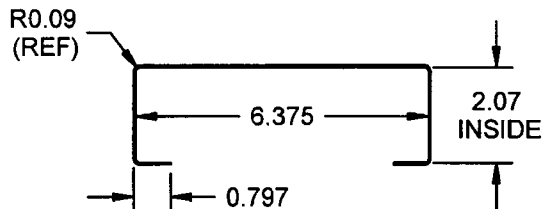
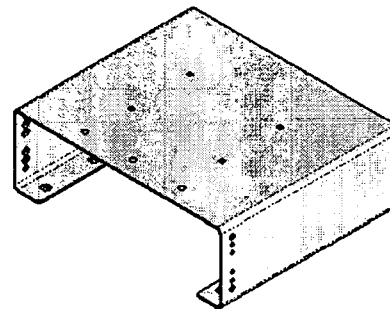
D3514-3F FLAT PATTERN



DETAIL D
SCALE 1:2

DRILL #27 ($\phi 0.144$)
(4 PLACES)

DRILL #40 ($\phi 0.098$)
C'SINK $\phi 0.182 \times 100^\circ$ THIS SIDE
(8 PLACES) FOR RIVETS



D3514-3 BOX TOP (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

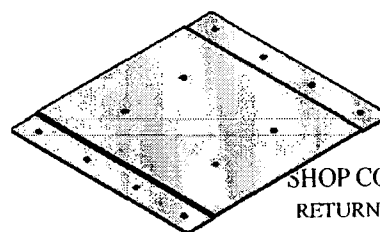
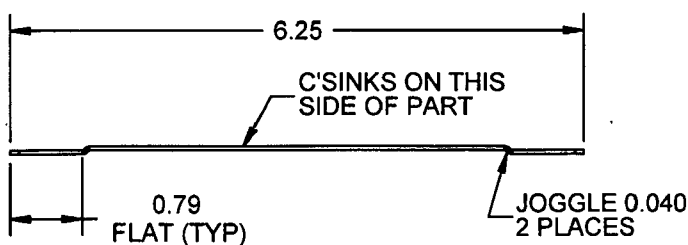
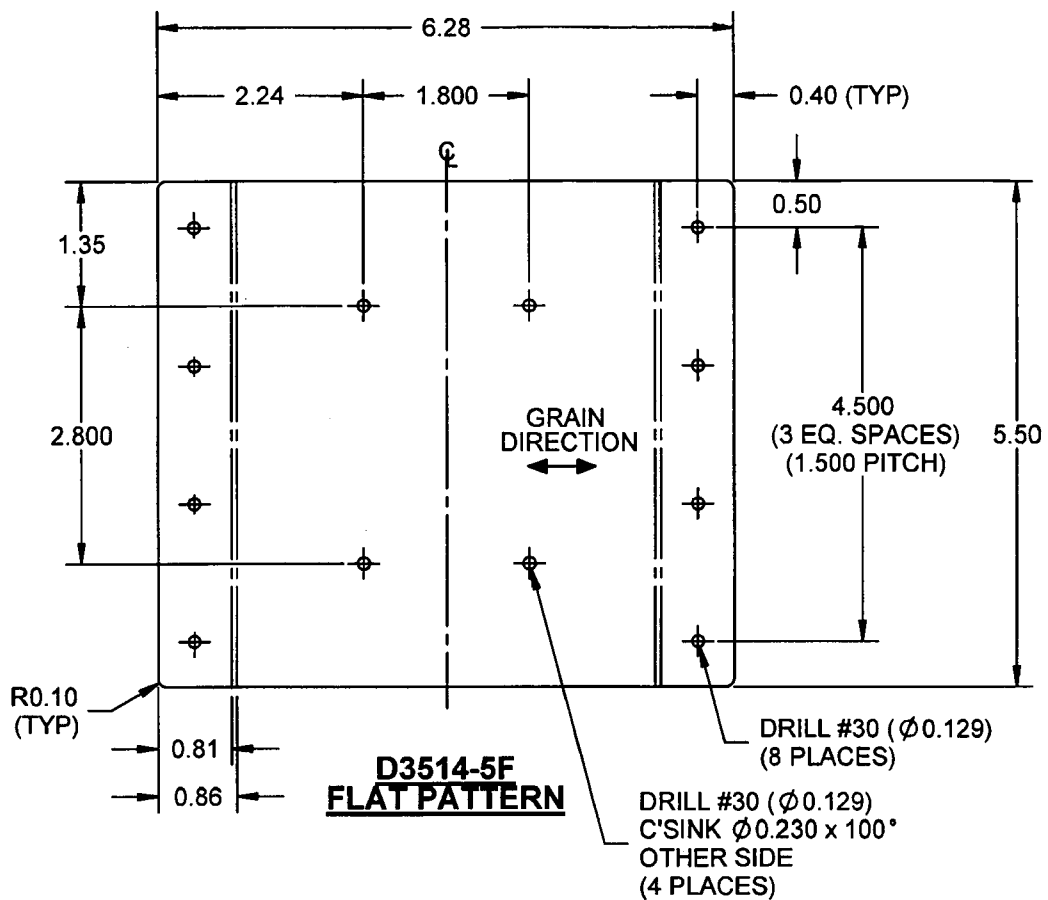
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514
DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 7 OF 9 SCALE 1:2



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NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINK ABOVE JOGGLE

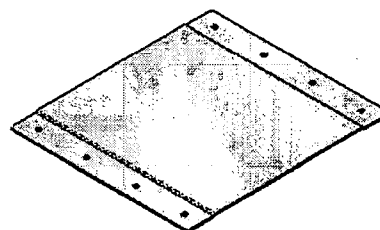
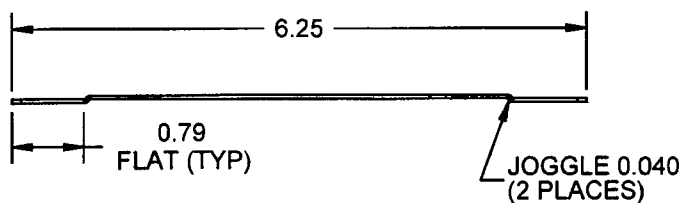
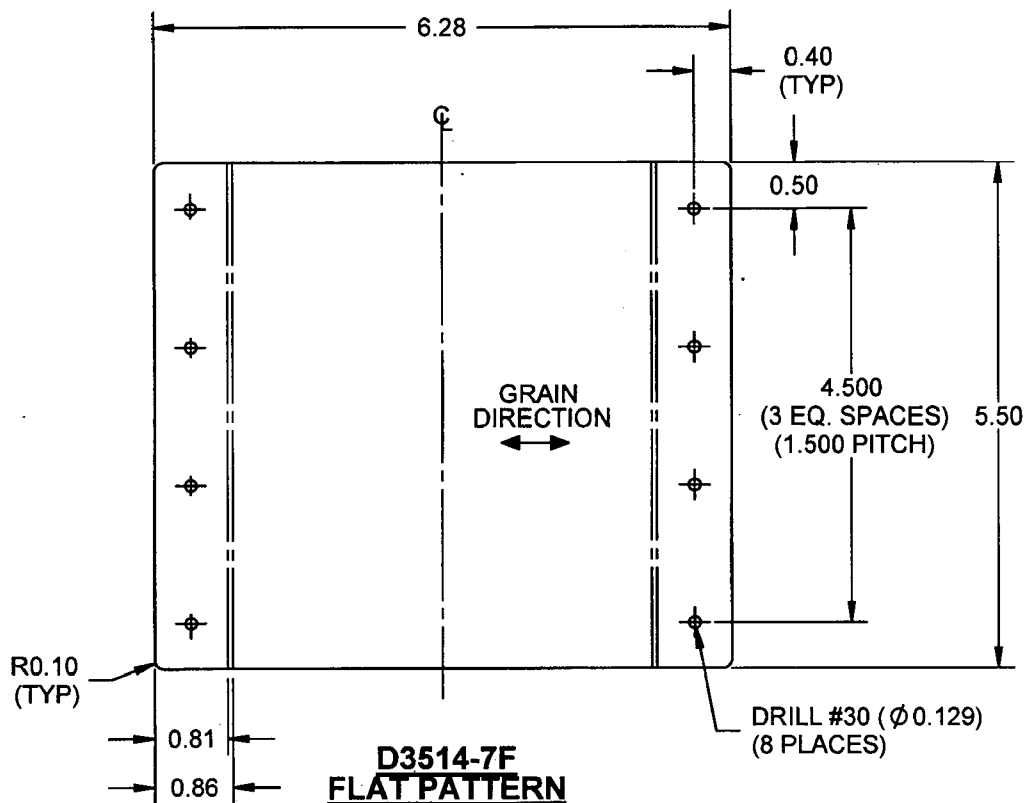
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07.08.03 **[Signature]**

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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	REV. A SHEET 8 OF 9 SCALE 1:2



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NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

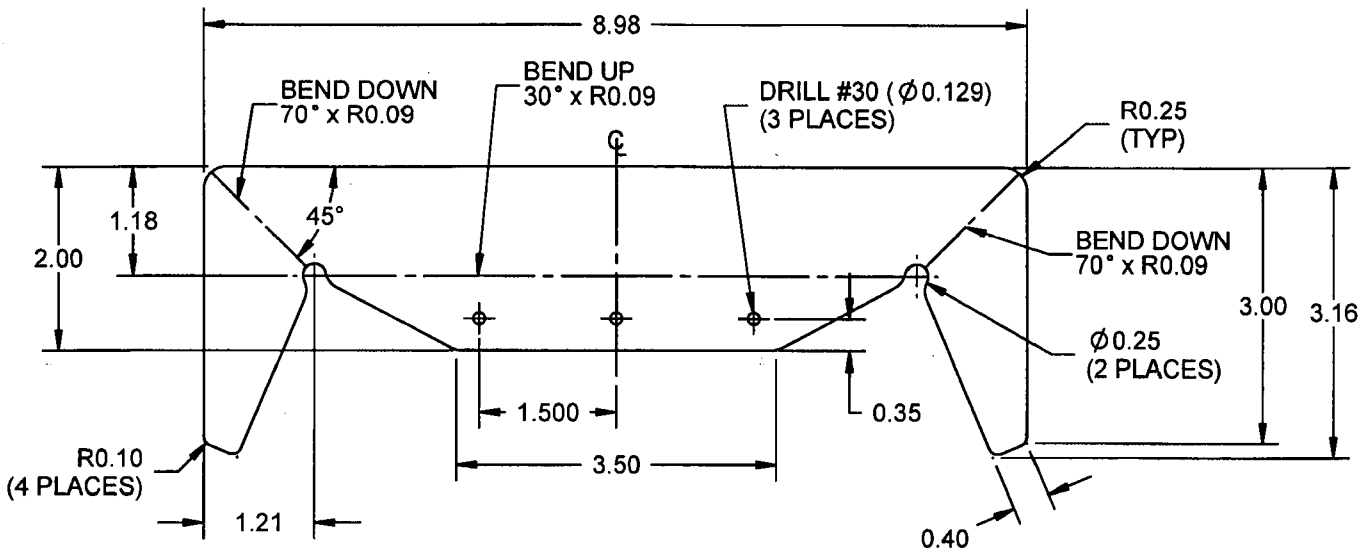
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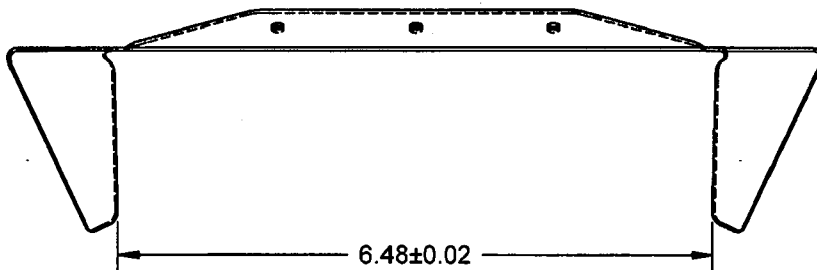
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DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 9 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



D3514-9F
FLAT PATTERN



FRONT VIEW

D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
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- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

RELEASED
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEG

Job Number: 35752

Part Number: D35233

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.12.03 (X12)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

FL 07/12/05 (12)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

-Mask threaded holes & Ball as per Dwg D3523

-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

E N/A

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SA 07/12/12 (12)

10.0

MS21209F120

HELI COIL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

HELI COIL

Batch: M104996

REFERENCE ONLY

B.A/mr 07/12/14

11.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Install Helicoil as per Dwg D3523

B.A/mr 07/12/14

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/12/14 (12)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 11007

7/12/17 SA (12X)